



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3201-4

Job Sheet 179208



Part No: D3201-4

Job Qty: 4 ea

Part Name: Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev: B Now on Waterjet 06-08-14 JLM IPP Rev: C Added scribing, NCR262 07.11.29 EC IPP Rev: D 10.10.29 remove scribe b# & p# DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/28/18	6/28/18	0.00	0.00	Start Up Waterjet		SC 18/06/19
100	Waterjet	4 pcs	6/28/18	6/28/18	0.00	0.09	Waterjet1		SC 15/06/19
120	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC8		38
140	Brake NC	4 pcs	6/28/18	6/28/18	0.09	0.09	Brake NC 1		9-89 DAS
150	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC5		38
160	HandFinish	4 pcs	6/28/18	6/28/18	0.00	0.11	HandFinish1		BE 8/10/18-26
170	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC7-2		38
180	Packaging	4 pcs	6/28/18	6/28/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	4 Ea	6/28/18	6/28/18	0.00	0.00	QC21		JUN 26 2018
Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING)									
Descriptions: 140 - 1-Bend as per Dwg D3201									
DAS 21 JUN 27 2018									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.1800 sf (.045 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	0	83	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches ± 0.030	3.790 3.730	3,753	
2	Doubler	3.460inches ± 0.030	3.490 3.430	3,456	
3	Doubler	1.680inches ± 0.030	1.710 1.650	1,678	
4	Doubler	0.050inches ± 0.010	0.060 0.040	0,050	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		AGAINST DEPARTMENT/PROCESS		DISPOSITION		Work Order update only	
Part No. _____	Water Jet	Cross tube	Skid-tube	Rework	Small Fab	Engineering	
NCR No. _____	Prod. Eng. Coord.	Finishing	Machining	Scrap	Thermoforming	Quality	
	Rec/Store/Packaging	Composite	Large Fab	Use-as-is		Other	
	Supplier			Suspected Unapproved			
Date: _____	Step #: _____		QTY Effective: _____		MRB (QS1042) Approval		
Description Work Order		Completed By					
		Lead hand / Supervisor Approval Verification					
		QC / QA Coordinator Approval					
		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
		Container No: S082458					
		Part: D3201-4					
		Job No: 179208					
		Serial No/Batch: S082458					
		Revision: _____					
		Inspector: _____					
		Exp Date: _____					
		Instructions: _____					
		Date: 06/19/18					
		Wrong Stock Pulled					
		Out of Sequence					
		Off-set					
		Mislabeled					
		Fit/Function					
		Misaligned/off center					
		Positioned Wrong					
		Outside Dimensions					
		Over/Under tolerance					
		Part Incorrect					
		Part Lost/Missing					
		Part Moved					
		Drawing					
		Finish					
		Misread					
		Turning Sequence					
		Wrong Stock Pulled					
		Out of Sequence					
		Off-set					
		Mislabeled					
		Fit/Function					
		Misaligned/off center					
		Inspection incomplete/Unqualified					
		Contamination					
		Countersink					
		Cut Too Short					
		Instructions Incomplete/Unclear					
		Drill Holes					
		Crushing					
		Heat Treat					
		Wave/Twist in Tube					
		Marks/Chatter					
		OTHER: _____					
		Past Due					
		Manufacturing Process					
		Process Improvement					
		Product Improvement					
		Rushing					
		Poor Information					
		Use for Testing					
		Training					
		Supplier					
		Offset/Setup					
		Operator					
		No Re-verification					
		Environment					
		Design					
		Doc/Data					
		Equip/Tooling					
		Handling/Pre					
		Material					
		Internal Transport					
		Tribal Knowledge					
		LOA					
		Substation					
		Past Expiry Date					
		Misidentified					